

Work Order ID 50748

July 21, 2009 12:44:00 PM



Page 1

Item ID: D2017-131

Accept



Setup Start



Revision ID: E

Stop



Item Name: Step Strut

Start Date: 7/06/09 Start Qty: 2.00

Cust Item ID:

Required Date: 7/06/09 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: *U*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2017

Rev F

100

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

90

E

Punch as per Draw + Deburr

8/09/09

M. K. O. A. L. O. A. / 10

(2X)

110

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

M112260

0.00

Powder Coating

START TIME:

11:15am

OVEN TEMPERATURE:

11:45am FINISH TIME:

400°F

120

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Bl 0209-14

(2)

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Page 2

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Item Name: Step Strut

Setup Start

Stop

Start Date: 7/06/09 Start Qty: 2.00

Required Date: 7/06/09 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location 258

0.00



Packaging

Memo

0.00

Packaging

7/9/14

(2x) SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/15 *[Signature]*
Bt 09-9-15

Status	Item ID	Rev	Name	Start Date	Quantity	PeJOMp	Date	Secrap	ap	Qua	mmeind	NEC	ILCX	ISortme	Offse	an	Ty1	Per	Och	to	Vore	Ce	Last	Id	Da
✓	M304TR0.750W.049		304 RD Tube .750...	6/24/09	2.6417	f		100	5	0.0...				1	0	M...							6/3...	6/...	

Picklist Print

July 22, 2009 12:20:25 PM

Page 1

Work Order ID: 50748

Parent Item: D2017-131RevE

Parent Item Name: Step Strut

Comments:

Start Date: 7/06/09

Required Date: 7/06/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No				f	350.2300	5.2900			



304 RD Tube .750 x .049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

350.2300026

107518

7.27

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

111619

13.2700026

112187

300

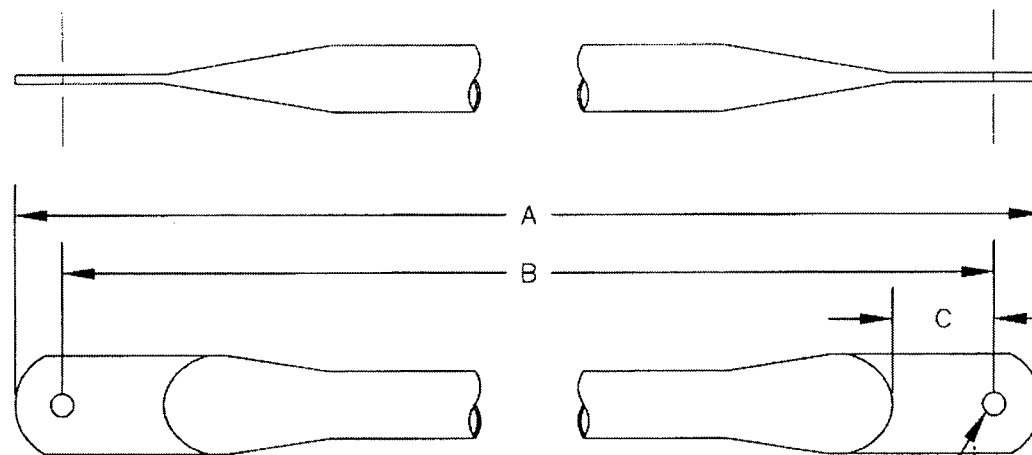
6

80 09/09/09 (2)

ALL INFORMATION CONTAINED
HEREIN IS UNCLASSIFIED
DATE 08-22-2011 BY 60322
UCBAW

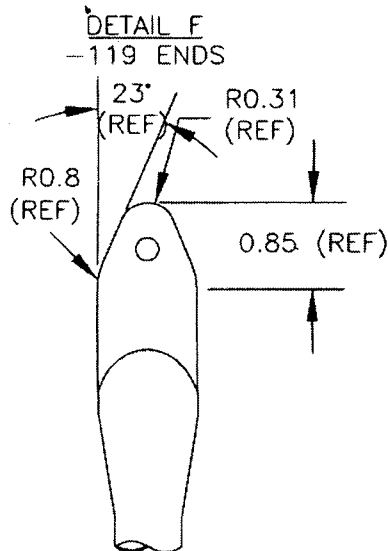
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40
50748



PUNCH ENDS PER
SPEC CTRL D2638
(-119 SEE NOTE)

"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)
"E" DIA TO BE OPENED MANUALLY (ONE END ONLY)



Part Number	A	B	C	D	E
D2017-101	17.73	16.93	1.30	0.250	0.312
D2017-103	18.74	17.94	1.30	0.250	0.312
D2017-105	14.95	14.15	1.30	0.250	-
D2017-107	15.61	14.81	1.30	0.250	-
D2017-109	13.93	13.13	1.30	0.250	-
D2017-111	15.30	14.50	1.30	0.250	-
D2017-113	20.50	19.70	1.30	0.250	0.312
D2017-115	12.42	11.62	1.30	0.250	-
D2017-117	13.86	13.06	1.30	0.250	-
D2017-119	26.75	25.95	1.30	0.250	-
D2017-121	12.30	11.50	1.30	0.250	-
D2017-123	12.92	12.12	1.30	0.250	-
D2017-125	19.55	18.75	1.30	0.250	-
D2017-127	20.30	19.50	1.30	0.250	-
D2017-129	31.43	30.63	1.30	0.250	-
D2017-131	19.68	18.88	1.30	0.250	-
D2017-133	30.66	29.86	1.13	0.250	-

NOTE:

FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)
BEND FLARED ENDS 8" UP/ 8" DOWN

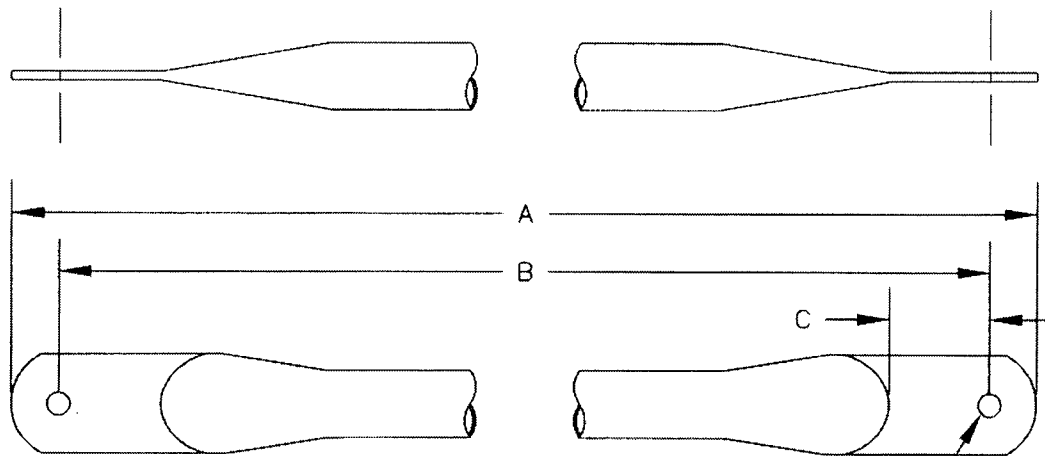
MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN BW	DRAWN BY 11	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. E
CHECKED HE	APPROVED TH	DRAWING NO. D2017	SHEET 1 OF 2	
DATE 99.04.16	TITLE STEP STRUTS		SCALE NTS	
C	95.01.26	ADDED PARTS		
D	96.03.28	ADD PARTS		
E	99.04.16	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897)		

DART



RELEASED
DATE: 01-11-16
RC



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

Part Number	A	B	C	D
D2017-201	21.31	20.51	1.30	0.250
D2017-203	16.39	15.59	1.30	0.250
D2017-205	16.53	15.73	1.30	0.250
D2017-207	13.85	13.05	1.30	0.250
D2017-209	15.64	15.33	1.30	0.250
D2017-211	15.67	14.87	1.30	0.250
D2017-213	15.82	15.02	1.30	0.250
D2017-215	16.47	15.67	1.30	0.250
D2017-217	16.70	15.90	1.30	0.250
D2017-219	13.65	12.85	1.30	0.250
D2017-221	13.58	12.78	1.30	0.250
D2017-223	12.95	12.15	1.30	0.250
D2017-225	13.99	13.19	1.30	0.250
D2017-227	30.67	29.87	1.30	0.250

50748

NOTE:

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH KINDER (AT NUTS) (4352) PER DART QSI 018 43/11

DESIGN	BW	DRAWN BY	11	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	KE	APPROVED	TH		DRAWING NO. D2017
DATE	99.04.16			TITLE	SCALE
STEP STRUTS				NTS	